

Date: Monday, 1/14/2008 2:37:02 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 36748					
Estimate Number	: 10256					
P.O. Number	:		Part Number	: D22303		
This Issue	: 1/14/2008	S.O. No. :	Drawing Number	: D2230 REV F		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type	MACHINED PARTS	Drawing Revision	: F	
Previous Run	: 35800		Material	:		
Written By	:		Due Date	: 2/15/2008 Qty: 200 Um: Each		
Checked & Approved By	:					
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)

Lug Extrusion

D2423

Batch: B33310

2.0	BAND SAW	BAND SAW
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cut at platec



Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: _____

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Issue PO 5448



CLog/01/15

(200)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Receive & Inspect for visual damage ensure C of C attached
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INSPECT PARTS AS THEY COME OFF MACHINE
Receive & Inspect for visual damage
ensure C of C attached

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QCB	SECOND CHECK
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SECOND CHECK



Comment: SECOND CHECK Inspect levels

QSP 019

counts

08/01/08 (201)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: MOUNTING LUG
Job Number: 36748		Part Number: D22303
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble and deburr rough edges after tumbling		
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
8.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
9.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/INSPECT POWDER COAT		
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 476		
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		
W		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

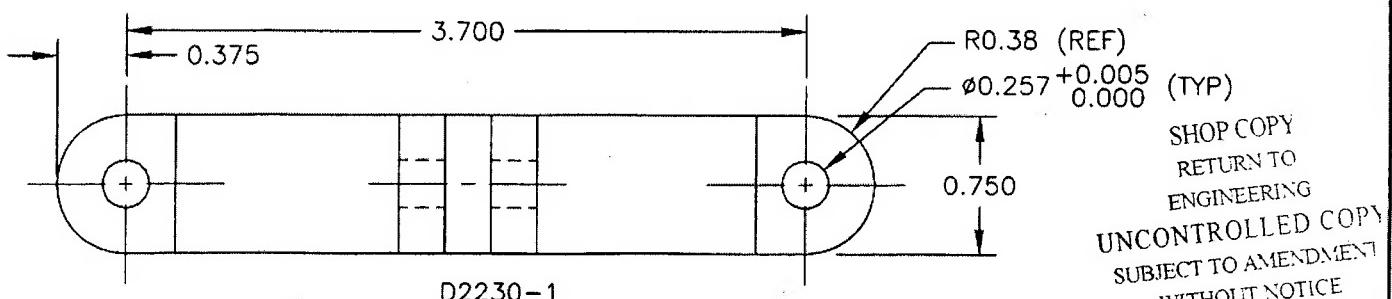
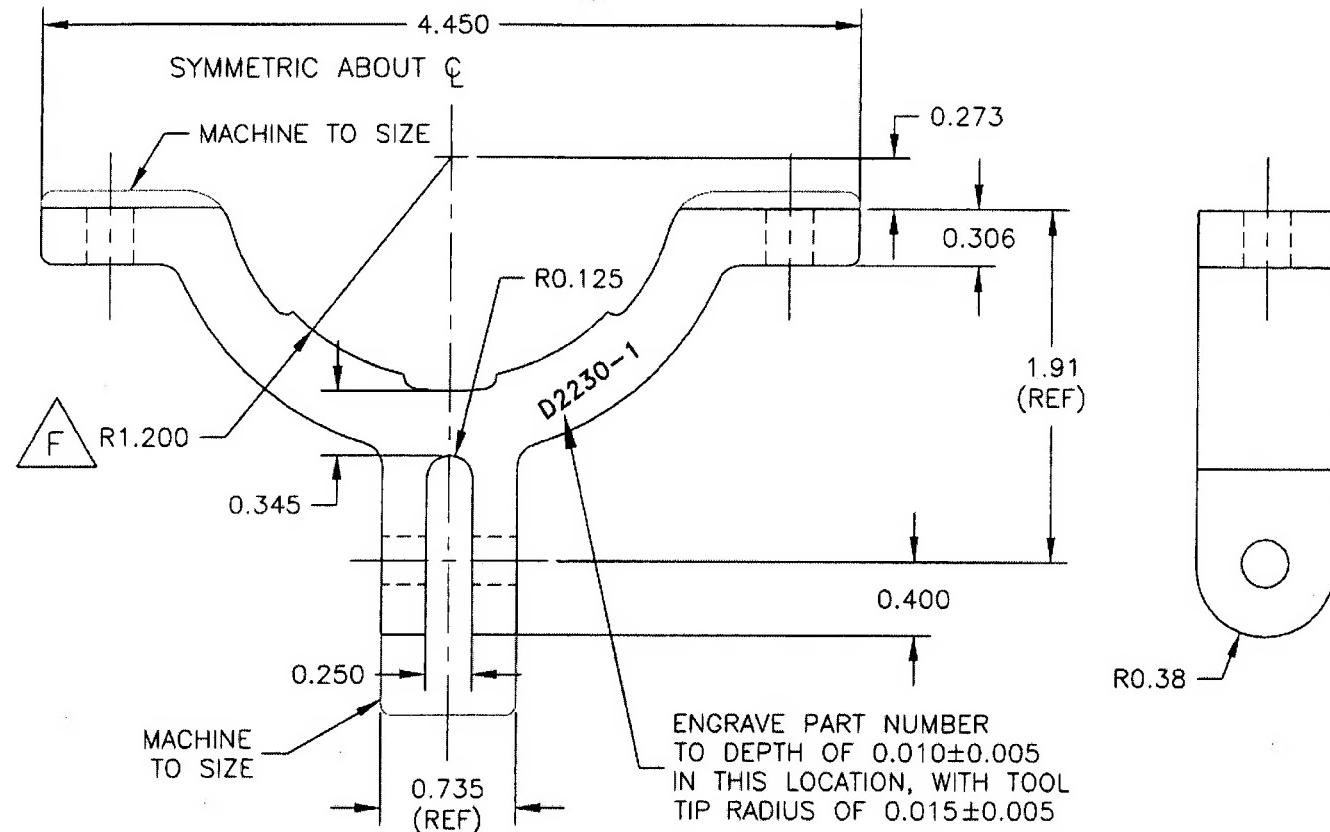
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 1 OF 2
99.12.13		TITLE MOUNTING LUG
		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2230
DATE	99.12.13			TITLE MOUNTING LUG

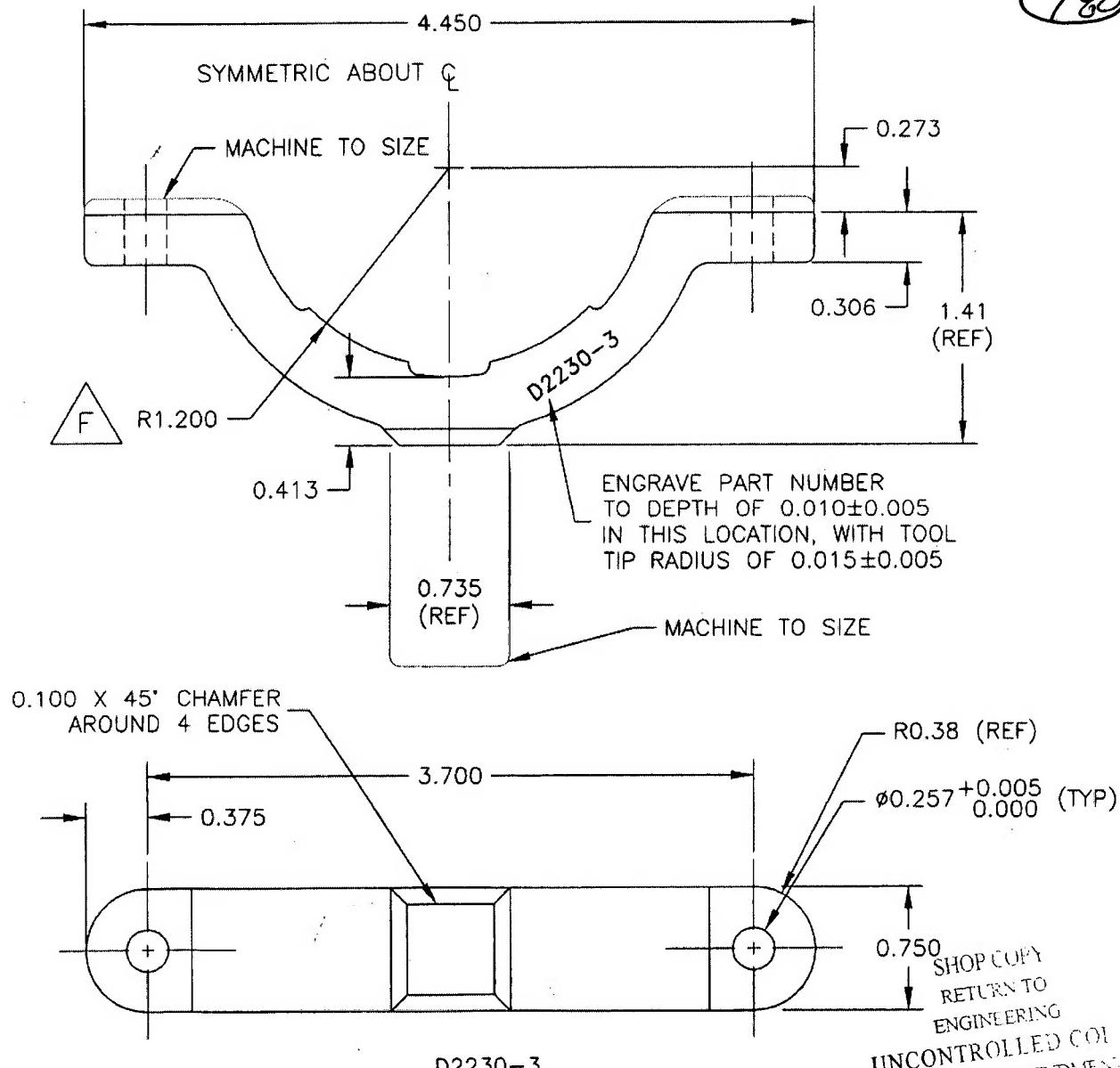
REV. F

SHEET 2 OF 2

1:1

RELEASED

99.12.21 DS

(60)
(+2)
180

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
201	D2230-3	Lug B36748	5448

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, January 25, 2008